July-30-12 10:18:15 AM

Item ID:

D3914-7

Accept

N900040100

Setup Start

Revision ID:

Start Date:.

Item Name: Rib

> 30/07/2012 Start Qty: 4.00

Required Date: 13/08/2012

Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/07 30 Tooling:

Date:

Run

Stop

QC	Dat	e:	SPC (Y/N):	Da	ite:			Stop *NR2			
Sequence ID/ Work Center ID	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	:									
D3914	В				,						
100				0.00							
100 Large Fab		Memo		0.00			(×5)	CC	13-1-23	<u> </u>
Large Fab		1- Cut tube as per do 2- debur and remove		arkings							•

110 .

QC6- Inspect dimensions to drawing

0.00

110

Quality Control

QC

Memo

0.00



120

120

Packaging Packaging

Memo

Identify as per dwg & Stock Location. WA OOU

0.00

0.00

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE																
									,		QA Closed:	Da	ite:			
Work Orde	er: _					DISPOSITION	1	AGAINST DEPARTMENT/PROCESS								
Part No						Rework Scrap Use-as-is		1	Skid-tube Crosstube Machining Small Fab noforming Finishing		4	Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other		
NCR No.						Work Order Update			Large Fab Composite		i nec/stor	Supplier	-	other 📙		
Root					Descri	ption of work order update		Initial	Action		Sign &					
Cause	,	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description		Date	Verification	n	QC Inspector		
Doc/Data	Ц															
Equip/Tooling	Ш															
Operator	Ш															
Material	Ш															
Setup	Н															
Other	Н						İ]					
Process	Н															
Supplier	Н								·							
Training	Н															
Unapproved						<u> </u>	<u> </u>									
1							AUL	T CATE	GORY	_						
Landi						General	_	16		_	1		ſ	la /e		
	\vdash	Bending		_ 4	a/s .	Bend	_	Grain		 	Ovalized		_	Pressure/Forced		
Ė.		Çentre No Cracks	t Concer	itric to t	J/S -	BOM/Route	<u> </u>	Hardwa		<u> </u>	Over/Under		-	Temperature/Cure		
	Ш		- · ·		<u> </u>	Broken/Damaged	<u> </u>	i '	on Incomplete	<u> </u>	Part Incorred		-	Weld		
	_	Crushed/(rimped.			Burrs	\vdash	4	ions Incomplete/Unclear	\vdash	Part Lost/Mi	ssing		Wrong Stock Pulled		
		Cuffs			-	Contamination	\vdash	Mainte		\vdash	Part Moved	_				
		Heat Trea			<u> </u>	Countersink	<u> </u>	Mislabe		<u> </u>	Positioned Wrong					
	-	nspection	•	Tube	<u> </u>	Cut Too Short	<u>_</u>	Misread	· ·	L	Power Loss/	Surge		Other		
	Ripples in Bend					Drill Holes	1	Offset								

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord July-30-12 10:				*886				Page			
Item ID: Revision ID: Item Name:	D3914-7		·	Accept	*N900	040	100) *	Setup Start	I VI	S1*
Start Date: 30/07/2012 Start Qty: 4.00 Required Date: 13/08/2012 Req'd Qty: 4.00 Reference:			*4 *4	*	Cust Item I Customer:	D:					
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):	Date:				Run Start Stop	"IV	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

130

130

Quality Control

Page 2

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE															
										i	QA Closed:	Da	ate:		
Work Orde	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Prod. Eng. Coo Rec/Store/Packagir				Engineering Quality Other		
Root				1	ption of work order update	1	nitial	Act			Sign &				
Cause	Dat	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	_	Date	Verification	'n	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								·							
					F/	AUL	T CATE	GORY							
Landi	ng Gear				General		-	•						_	
.•	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled				Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	ct ssing		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled			
		tion Strip in	Tube		Cut Too Short		Misread		-	_	Power Loss/	_		Other	
	Ripples in Bend				Drill Holes		Offset			1	J	_	······································		

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Picklist Print

July-30-12 10:18:18 AM

Work Order ID: 88651

Parent Item:

D3914-7

Parent Item Name: Rib

88651

D3914-7

Start Date: 30/07/2012

Required Date: 13/08/2012

Start Qty: 4.00

Required Oty: 4.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

· IPP Rev:B as IPP Rev:C 11.01.18 chg

per dwg revB DD 10.08.18 verified by:EC

qc5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049		Purchased	No			100	f	1,049.099	7.875	33.15789			

M304TS0 500W 049

Square Tubing

Location	Loc Qty	Loc Code	
MAT018	644 <i>B</i> /	22938 -	-> <u>41.44736</u>
122413	644		· · · · · · · · · · · · · · · · · · ·
MAT034	405.0995823		
118460	0.00001534		
121328	2.059994		
121565	20.775743		
121808	382.26383		

Page 1

												DQA:	Da	te:		
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE		•	· · · · · · · · · · · · · · · · · · ·	•		
										·	QA	Closed:	Da	te:		
Work Ord	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No						Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite				Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other		
Root		-			Descri	otion of work order update		Initial	Ac	tion	S	ign &				
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved																
l and:							AUL	LT CATE	<u> </u>							
Landi	Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube				o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instructi Mainte Mislabe Misread	on Incomplete for s Incomplete/ nance led	Unclear	Ove Par Par Par Pos	alized er/Under t Incorred t Lost/Mi t Moved sitioned V wer Loss/	ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
1	ıi	Ripples in	Rena		I	Drill Holes	1	Offset								

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